

Split **Work Order ID 70869 - 2**

Thursday, June 16, 2011 12:43:40 PM



Page 1

Item ID: D3022-1

Revision ID:

Item Name: Seat Pan

Start Date: 6/16/2011 Start Qty: 1.00

Required Date: 6/24/2011 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: *W*

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

Draw Nbr

Revision Nbr

D3022

Rev B

100



Waterjet

FLOW CNC Waterjet

B.M. 037

FLOW WATER JET

0.00

Memo

0.00

1-Cut as per Dwg D3022

Dwg Rev: *B*

Prog Rev: *B*

*** grind direction along 31.700" ***

2-Deburr if necessary

B 11-6-16

(3)

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

B 11-6-16

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Setup Start



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Cust Item ID:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

8 w/ob 1/7

(+3)

130



Brake NC

Brake NC

Bend as per dwg
NC BRAKE

Memo

1- Bend as per Dwg D3022

0.00

0.00

50 w/ob 1/7

(3)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8 w/ob 1/7

(+3)

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Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Large Fab

Large Fab

Large Fab

Memo

0.00

1-Transfer drill Seat Pan From Frame
Transfer drill in D3022-1 using D3017-041

2-Deburr

11-11-17 *(X1)*

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

5/11/17

170



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005.4.1

0.00

Memo

0.00

1X Ø m-f 11/11/17

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Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

180



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

0.00

0.00

0.00

1X M. 11/11/17

190



QC

QC3- Inspect Part Finish

0.00

Quality Control

Memo

0.00

1 BR 11-11-17.

200



Packaging

Identify as per dwg & Stock Location:

0.00

Packaging

Memo

0.00

EP 11/11/18 @

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Accept



Setup Start

Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/23

U 11.11.23

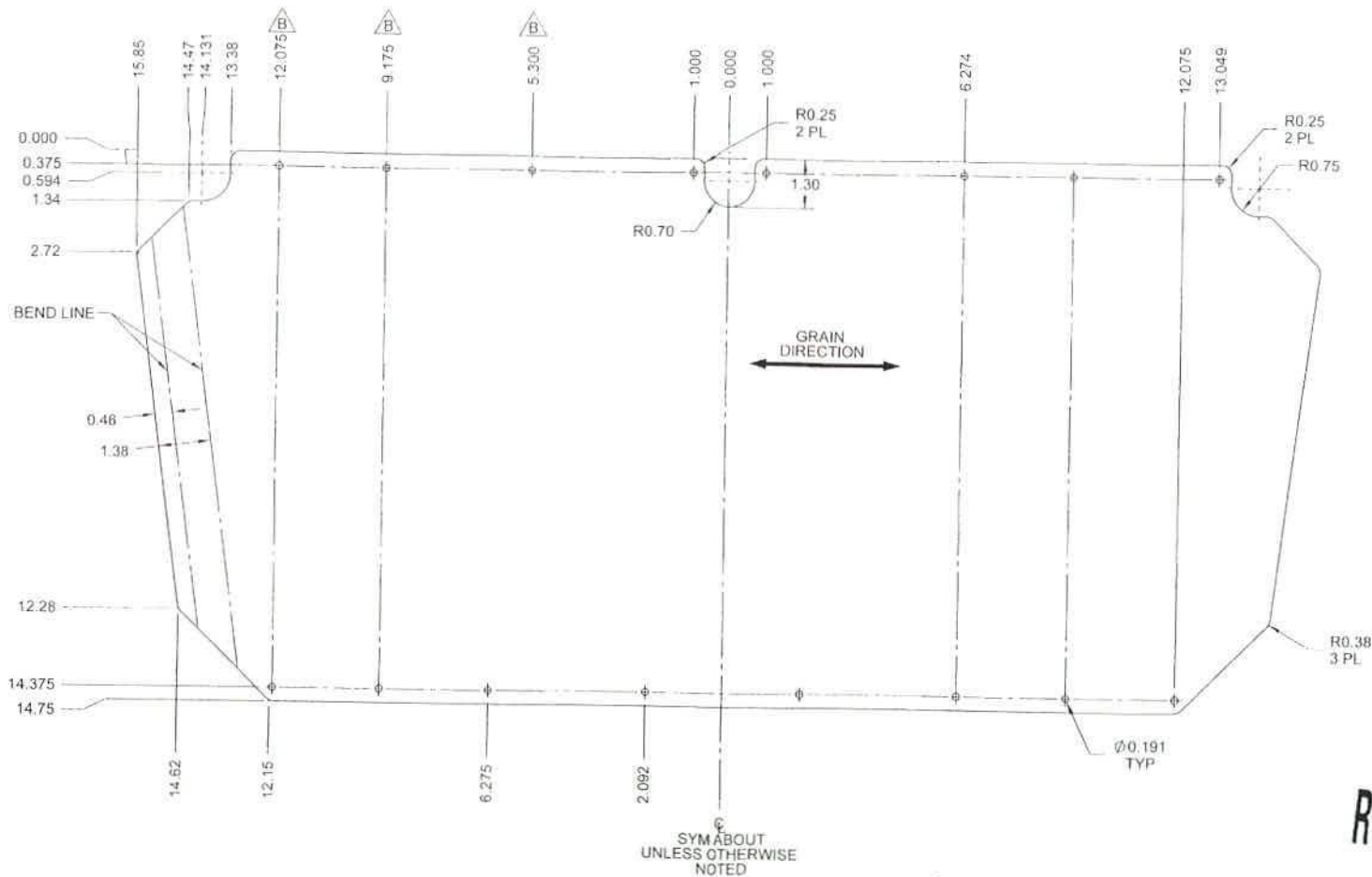
Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Issue	M2024T3S.032 / 2024-T3 .032 sheet	Main Warehouse MAT22	68733	DCUSER		49.5000		49.0000		
					4/21/11	-3.0000	113189	-3.0000		-\$10.27
		Main Warehouse MAT22	69131	DCUSER		46.5000		46.0000		
					5/03/11	-3.3000	113189	-3.3000		-\$11.30
		Main Warehouse MAT22	68710	DCUSER		43.2000		42.7000		
					5/03/11	-3.3000	113189	-3.3000		-\$11.30
		Main Warehouse MAT22	70018	DCUSER		39.9000		39.4000		
					5/30/11	-3.0000	113189	-3.0000		-\$10.27
		Main Warehouse MAT22	70017	DCUSER		36.9000		36.4000		
					5/30/11	-3.0000	113189	-3.0000		-\$10.27
		Main Warehouse MAT22	70019	DCUSER		33.9000		33.4000		
					5/30/11	-2.0000	113189	-2.0000		-\$6.85
		Main Warehouse MAT22	70020	DCUSER		31.9000		31.4000		
					5/30/11	-1.5000	113189	-1.5000		-\$5.14
		Main Warehouse MAT22	70869	DCUSER		30.4000		29.9000		
					6/16/11	-6.0000	113189	-6.0000		-\$20.55
		Main Warehouse MAT22	72276	FAUT01		201.9000		23.9000		
					8/08/11	-3.5000	113189	-3.5000		-\$11.99
		Main Warehouse MAT22	71682	DCUSER		198.4000		20.4000		
					8/15/11	-16.6000	113189	-16.6000		-\$56.85
		Main Warehouse MAT22	71629	DCUSER		181.8000		3.8000		
					8/15/11	-16.6000	113189	-3.8000		-\$13.01
								-157.2168		-\$538.44
	M2024T3S.050 / 2024-T3 .050 sheet	Main Warehouse MAT	54982	DCUSER		172.3533		48.0000		
					1/07/10	-2.7000	113189	-2.7000		-\$11.19
		Main Warehouse MAT22	57572	DCUSER		47.0000		4.0000		
					4/13/10	-2.1000	113189	-2.1000		-\$8.71

No pick sheet
on original

November-17-11 11:13:40 AM

Location/Lot Activity

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RELEASED
28/12/15

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
REF DART SPEC M2024T3S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.36 lbs

D3022-1F SEAT PAN

Handwritten signature/initials

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3022	REV. B
MFG. APPR.		TITLE SEAT PAN	SHEET 3 OF 3
APPROVED		SCALE NTS	
DE APPR.		DATE 08.11.27	

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